Page 1 Tuesday, March 12, 2013 9:53:04 AM Item ID: D3210-1 Accept *N900040100* Setup Start **Revision ID:** Stop Item Name: Doubler **Start Date: Start Qty: 12.00** *12* 3/12/2013 **Cust Item ID: Required Date: 3/15/2013** Req'd Oty: 12.00 *12* **Customer:** Reference: SWE Run Start Date: 13-12-Tooling: Process Plan: Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Set Up/ Tool # Plan Accept Reject Reject Insp. **Work Center ID** Description **Run Hours** Qty Code Qty Number Stamp Draw Nbr **Revision Nbr** D3210 В 100 0.00 FLOW WATER JET *100* Jm 13.3. 12 13 Waterjet 0.00 Memo FLOW CNC Waterjet 1-Cut as per Dwg D3210 Dwg Rev: 080. P60S Prog Rev: 2-Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 *110*

Jm 13-3-12

Work Order ID 98242

QC

Quality Control

0.00

Memo

NCR:	Yes	/	No

DQA: _____ Date: _____

NCR: Y	es	/ No				WORK ORDER NON-	CON	FUKIN	MANCE / UPI	DATE	QA Closed:	Date	:
Vork Orde	r:					DISPOSITION				AGAINST DI	EPARTMENT,	/PROCESS	
Part N	•				·····	Rework Scrap]	ħ	Machining Small Fab Prod. Eng. Coor.				Engineering Quality
NCR N	lo.					Use-as-is Work Order Update	}	Thermoforming Finishing Large Fab Composite			Rec/Sto	re/Packaging Supplier	Other
Root Cause		Date	Step	Qty		ption of work order update or Non-conformance		nitial ef Eng		ion ription	Sign & Date	Verification	QC Inspector
oc/Data	\dashv	Date	step	Qty	•	or Non-comormance	Cin	er crig	Desci	iption	Date	verification	QC IIIspector
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Landi					_	General				_	-	_	
		Bending			ļ	Bend	-	Grain		_	Ovalized	_	Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route	-	Hardwa		_	Over/Under	<u> </u>	Temperature/Cure
		Cracks			<u> </u>	Broken/Damaged	-		on Incomplete	<u> </u>	Part Incorred	⊢	Weld
		Crushed/0	Crimped		L	Burrs	\blacksquare		ions Incomplete/l	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs			_	Contamination	1—1	Mainte		<u> </u>	Part Moved		;
		Heat Trea				Countersink	\vdash	Mislabe		<u> </u>	Positioned V	_	¬
		Inspection	•	Tube		Cut Too Short	-	Misread	I	L	Power Loss/	Surge	Other
	_	Ripples in				Drill Holes	\vdash	Offset					
	_	Torque W			n	Drawing	\vdash		Calibration				
		Turning S				Finish			sequence				
		Wave/Tw	ist in Tul	oe e	ı	Folio		Outside	Dimensions				

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Page 2

Insp.

Stamp

130 0.00 Small Fab *120* Small Fab 0.00 Memo Small Fab Deburr 140 QC5- Inspect part completeness to step on *140* QC 0.00 Memo Quality Control

Quality Control

												DQA:	Date:	
NCR: Y	es ,	/ No					WORK ORDER NON-C	100	VFORM	MANCE / UP	DATE			
												QA Closed:	Date:	
Work Orde	ŕ:						DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	:
Part N	o						Rework Scrap Use-as-is	Scrap Machining		Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other	
NCR N	o						Work Order Update]		Large Fab	Composite]	Supplier	
Root	T			:	Desc	rip	tion of work order update	П	nitial	Act	ion	Sign &		
Cause		Date	Step	Qty		0	r Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
oc/Data														
quip/Tooling														
perator]
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ther.														
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upplier	_							ŀ						
raining														
napproved												·		,
) F	AUL	T CATE	GORY				
Landir	ıg Ge	ear			_	_	General		_					_
	B	Bending			L		Bend		Grain		L	Ovalized		Pressure/Forced
		Centre No	t Concer	ntric to	o/s		BOM/Route		Hardwa	re	L	Over/Under	tolerance	Temperature/Cure
		Cracks					Broken/Damaged	L	Inspecti	on Incomplete	L	Part Incorred	:t	Weld
	c	Crushed/C	Crimped				Burrs		Instruct	ions Incomplete/U	Inclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	c	Cuffs					Contamination		Mainte	nance		Part Moved		-
	_]⊦	Heat Trea	t	,			Countersink		Mislabe	led		Positioned V	Vrong	_
	lı	nspection	n Strip in	Tube			Cut Too Short		Misread	I		Power Loss/	Surge	Other
{	F	Ripples in	Bend				Drill Holes		Offset		_			
j		Torque W	aves in E	xtrusio	n [Drawing	Ŀ	Out of 0	Calibration				
	Ţ	Turning Se	equence				Finish		Out of 9	Sequence				

Outside Dimensions

Wave/Twist in Tube

Folio

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160 Powdercoat Powder Coating

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Tuesday, March 12, 2013 9:53:04 AM Item ID: D3210-1 Accept *N900040100* Setup Start Revision ID: Item Name: Doubler Start Date: **Start Oty:** 12.00 3/12/2013 **Cust Item ID: Required Date:** 3/15/2013 Req'd Qty: 12.00 **Customer:** Reference: Run **Process Plan:** Approvals: Date: Tooling: Date: Stop OC: Date: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Tool # Plan Reject Set Up/ Accept Reject Insp. Work Center ID Description Oty Otv Stamp **Run Hours** Code Number 150 Chemical Conversion Coat per QSI005 4.1 0.00 *150* HandFinish 0.00 Memo Hand Finishing 155 QC7-Inspect Chemical Conversion Coat 0.00 12 \$ 13-3-13 OC 0.00 Memo Quality Control 160 0.00 12 & \$ 13-3-13

FINISH TIME:

Tuesday, March 12, 2013 9:53:04 AM Item ID: D3210-1 Accept *N900040100* Setup Start **Revision ID:** Item Name: Doubler **Start Date:** 3/12/2013 **Start Qty: 12.00 Cust Item ID:** Required Date: 3/15/2013 Req'd Qty: 12.00 **Customer:** Reference: Run **Approvals:** Process Plan: Date: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center 1D Description Run Hours Code Qty Qty Number Stamp 170 QC3- Inspect Part Finish *170* QC Memo Quality Control Identify as per dwg & Stock Location: 180 *120* Packaging 0.00 Memo Packaging 190 QC21- Final Inspection - Work Order Release 0.00 *190* OC 0.00 Memo Quality Control

J. M. S. P.

Picklist Print

Tuesday, March 12, 2013 9:53:03 AM

Work Order ID:

98242

Parent Item:

D3210-1

Parent Item Name:

Doubler

Start Date: 3/12/2013

Required Date: 3/15/2013

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A

New Issue 05-11-17 JLM

IPP Rev:B Now On Waterjet 06-10-24 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080 2024-T3 .080 sheet		Purchased	No			100	sf	406.6900	1.7	21 .473 684 22	1		JM13-3-12
				1 4!				<i>~</i>					

Location	Loc Qty	Loc Code	
MAT022	406.69		
. 105411	12		
109424	8		
113796	10		
114025	3.4		
117392	38.2		
118180	54		
119117	40.95		
120989	79.34		
123217	160.8		123217.

r W

									DQA:	Date:	
NCR: Yes	/ No				WORK ORDER NON-O	CONFORI	MANCE / UPI		QA Closed:	Date:	
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
					Rework	1 1	Skid-tube	Crosstube		Water Jet	Engineering
Part No.					Scrap		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	Therr	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR No.					Work Order Update]	Large Fab	Composite		Supplier	ļ
Root		T T		Descri	tion of work order update	Initial	Act	ion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Descr	iption	Date	Verification	QC Inspec
Doc/Data								•			
Equip/Tooling			ļ								
Operator	1					ļ					
Material	1]	ŀ							

QC Inspector

Landing	Gear	General			_	
	Bending	Bend		Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped	Burrs		Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination	Г	Maintenance	Part Moved	•
Г	Heat Treat	Countersink		Mislabeled	Positioned Wrong	 _
	Inspection Strip in Tube	Cut Too Short		Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes	Γ	Offset		
	Torque Waves in Extrusion	Drawing		Out of Calibration		
	Turning Sequence	Finish		Out of Sequence		
	Wave/Twist in Tube	Folio		Outside Dimensions		

FAULT CATEGORY

Setup Other Process Supplier Training Unapproved

DART AEROSPACE LTD	Work Order: 今分	242
Description: Doubler	Part Number:	D3210-1
Inspection Dwg: D3210 Rev: B	P	age 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.141	+0.005 -0.000	0.141	-		U	Jkm 01
Ø0.128	+0.005 -0.000	0.129"	_		V	
3.857	+/-0.010	3.857"	<u>-</u>		V	
17.750	+/-0.010	17.750"	-		Т	JIM06
20.15	+/-0.030	20.15	<u> </u>		T	
8.500	+/-0.010	8,497	~		ΥΥ	Produces
1.095	+/-0.010	1.095"	<u> </u>		V	
0.650	+/-0.010	0.658	-		V	
0.350	+/-0.010	0.355"			V	
						·
			DA:	•		

Measured by:	Audited by:	0.8	Preliminary Approval:	
Date: 13-3-12	Date:	13.03.13	Date:	

Date	Change	Revised by	Approved
03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF	
	Removed 14.607 dimension	KJ/JLM I	
12.10.26	Dwg Rev updated	KJ OU	
(04.06.15	03.12.15 New Issue P/O D350-567-015/-025/-031 04.06.15 Removed 14.607 dimension	03.12.15 New Issue P/O D350-567-015/-025/-031 KJ/RF 04.06.15 Removed 14.607 dimension KJ/JLM



